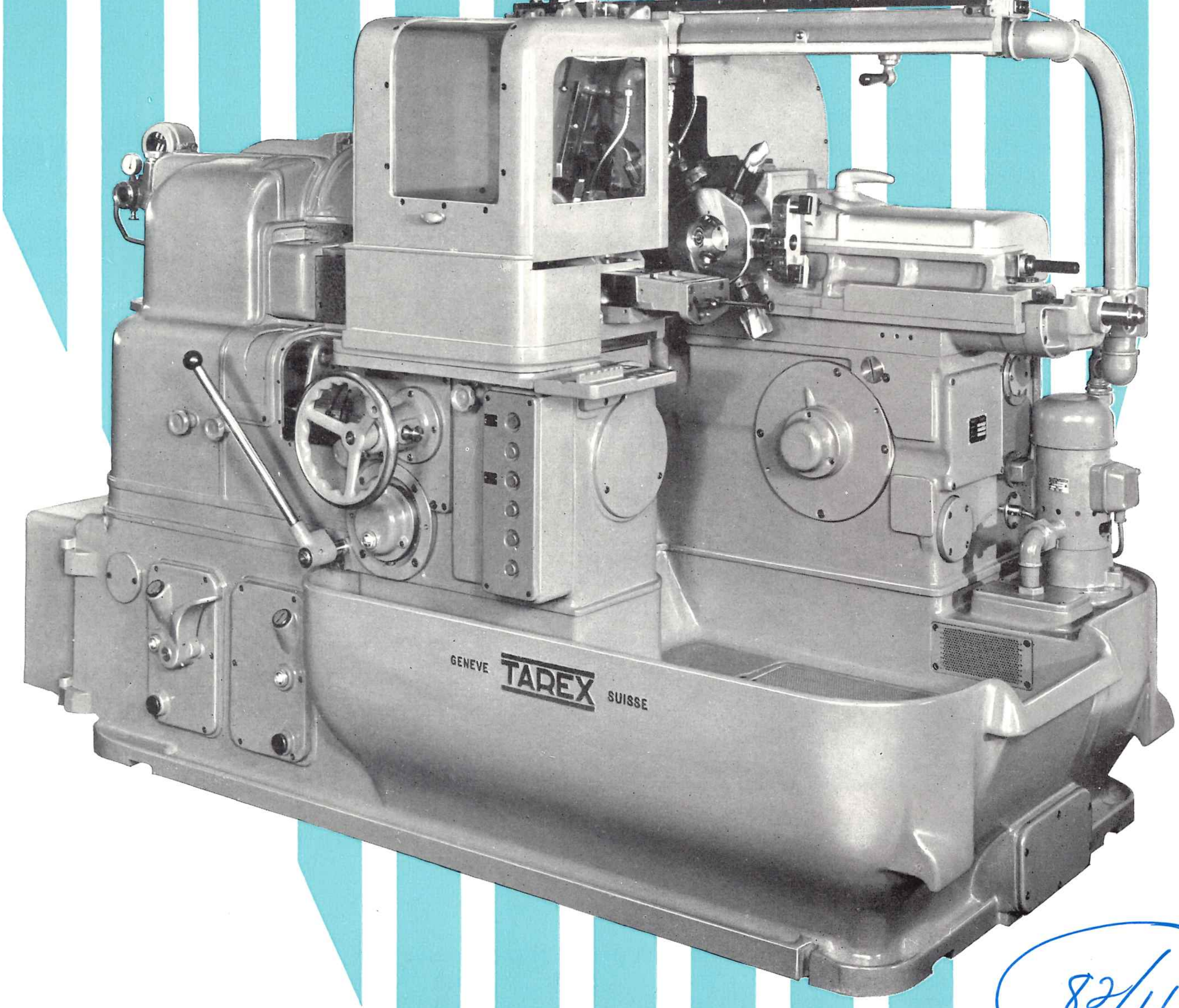
82 Catalog
117

SINGLE-SPINDLE AUTOMATIC TURRET-LATHES

TAR-H / MPS



82/117

Simplified machine with air-operated chuck

Machine Tool Show–
May 1st 1958 Phila, Pa.
Ted H.

TAREX

GENÈVE SUISSE

ANGLAIS

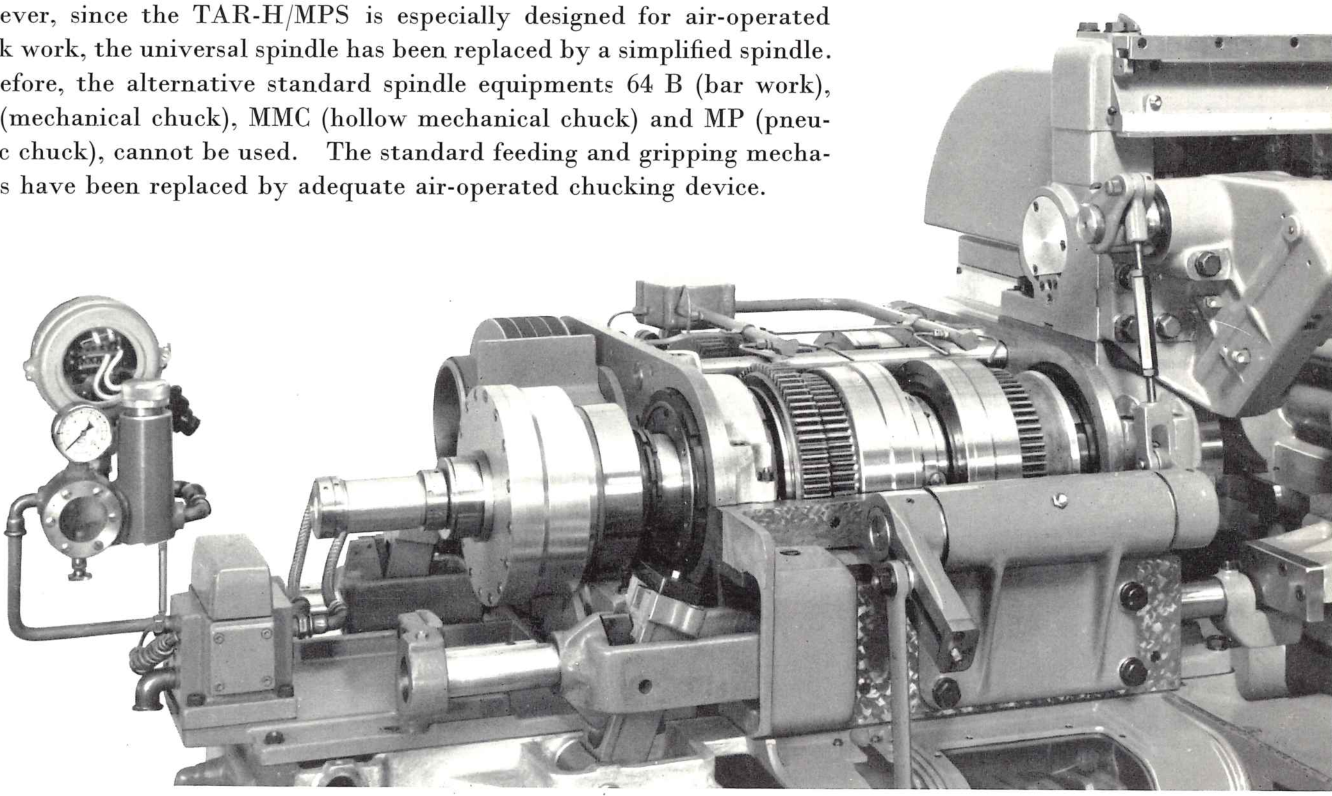
PRINTED IN SWITZERLAND

characteristics

This Machine has the same advantages as the standard TAR-H :

Six or eight position turret
Compound slide design of both front and back slide.
Vertical slide.
Complete independence of the movements of slides and turret.
Slides operated by standard flat cams and levers with adjustable ratio.
Accelerating mechanism to minimize idle time.
Standard attachments.

However, since the TAR-H/MPS is especially designed for air-operated chuck work, the universal spindle has been replaced by a simplified spindle. Therefore, the alternative standard spindle equipments 64 B (bar work), MM (mechanical chuck), MMC (hollow mechanical chuck) and MP (pneumatic chuck), cannot be used. The standard feeding and gripping mechanisms have been replaced by adequate air-operated chucking device.



All accessories and standard attachments of standard TAR-H can be mounted on TAR-H/MPS.

Spindle speeds

four automatic spindle speeds available with each pair of change gears:

2 reverse	2551	2027	1577	1240	1012	796	619	492
	728	579	450	354	289	227	177	140
2 forward	1086	863	671	528	430	339	263	209
	310	246	192	151	123	96	75	60

Motor : 12 HP.

Chucking

Max. chucking diameter	6″
Max. Swing	7″
Chucking tolerance	± .080″
Jaw travel	.200″
Air pressure	105 PS1 (6 kgs./cm²)

Shipping data

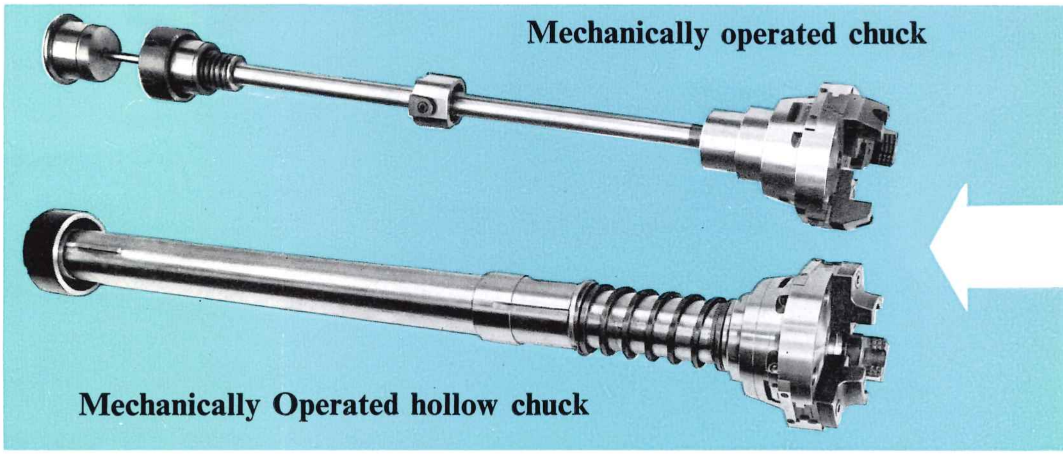
Basic machine, unpack.	6850 Lbs. (3300 kg.)
Lathe with standard equipment, crated	7700 Lbs. (3900 kg)
Packed for shipment	8400 Lbs. (3950 kg.)
Box measurements	5 ft. 3 in. × 9 ft. × 6 $^1/_2$ft (1,6 × 2,8 × 1,95 m)
Volume	320 cub. feet (9 m³)

advantages

An automatic lathe that counts for two

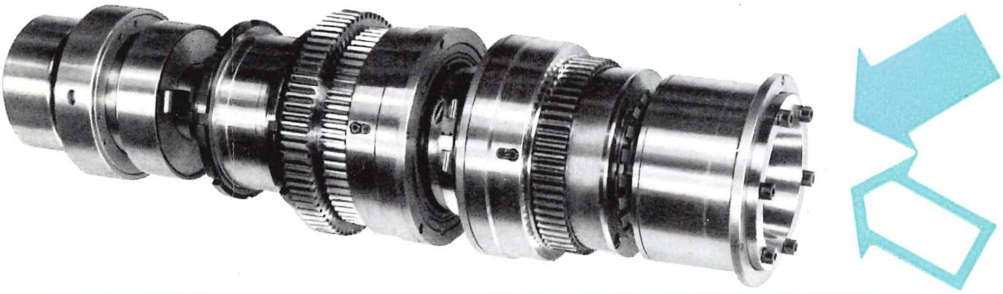
In the universal spindle of the " TAR H ", it is possible to incorporate either the gripping elements and their controls for bar work or for chuck work (castings, stampings and hot rolled bars).

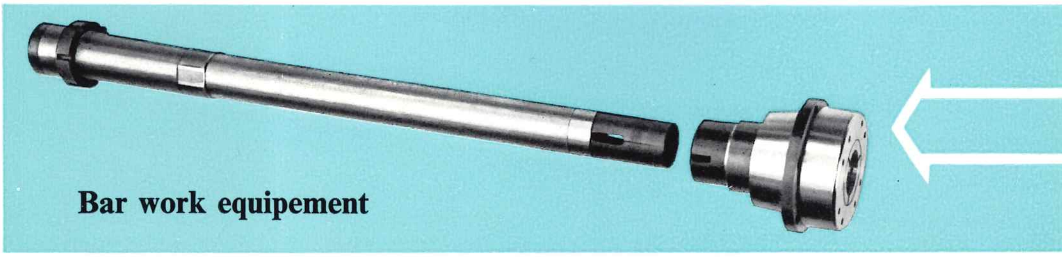
Change over from bar-work lathe to chuck-work and vice versa is quick and easy.



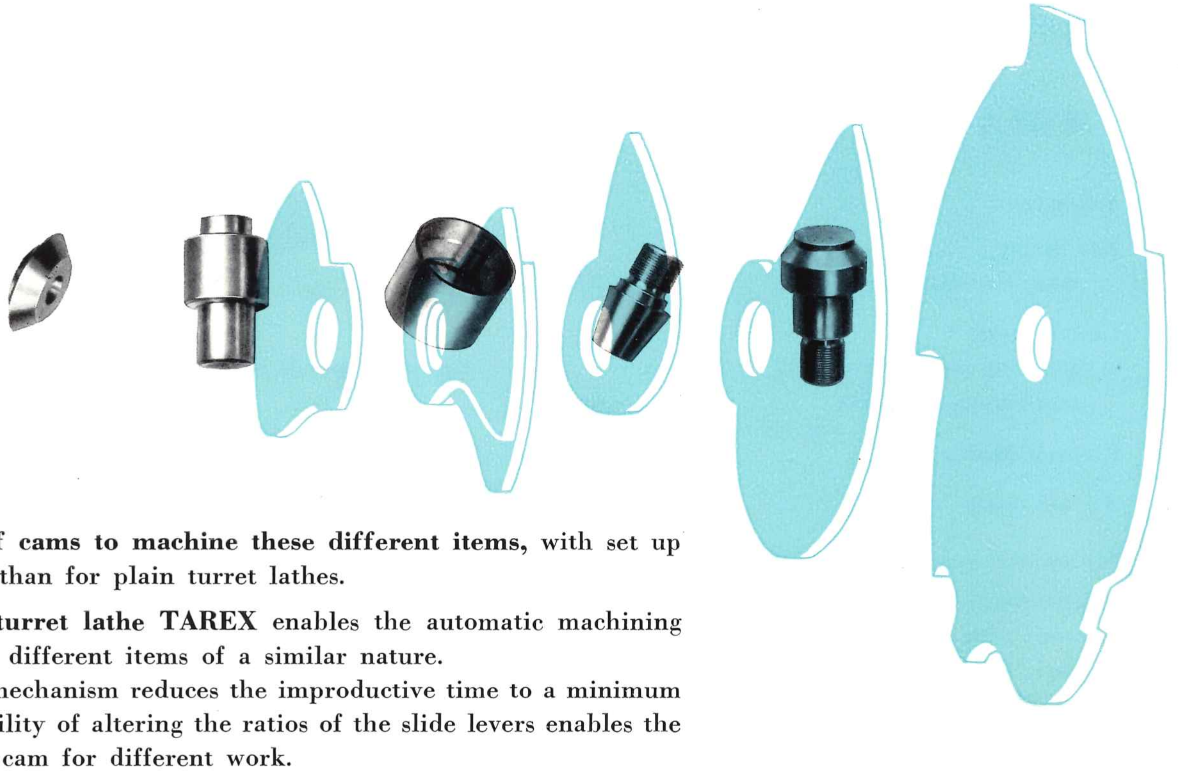
Mechanically operated chuck

Mechanically Operated hollow chuck





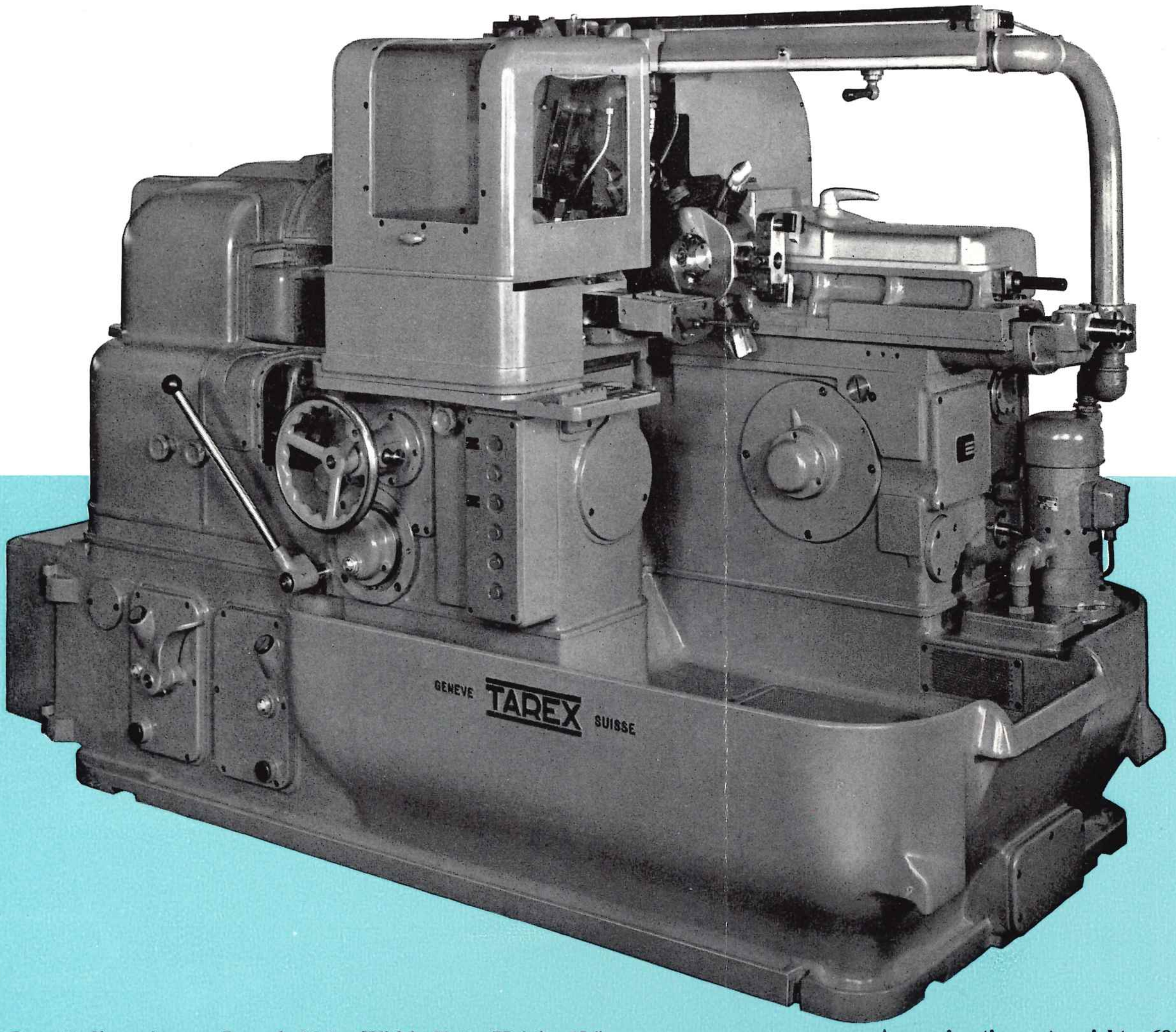
Bar work equipement



The same set of cams to machine these different items, with set up times no longer than for plain turret lathes.

The automatic turret lathe TAREX enables the automatic machining of small runs of different items of a similar nature.
Its accelerating mechanism reduces the improductive time to a minimum whilst the possibility of altering the ratios of the slide levers enables the use of the same cam for different work.

TAREX
GENÈVE



Overall dimensions : Length 95 ″ Width 50 ″ Height 65 ″ **Approximative net weight :** 6850 lb.

TAR H - 64 B MM

CHARACTERISTICS

Capacity :

Bar work	
max. bar diameter	2 1/2 ″
Chuck work	
gripping max. dia.	6 ″
machining max. dia.	7 ″
Electric-Motor	12 HP
Turret Slide stroke	4 3/4 ″
Slides strokes :	
Longitudinal stroke	
front slide	4 ″
back slide	19/32
Transversal stroke of the four slides	2 1/2 ″

Spindle speeds :

8 ranges of speeds, from 60 up to 2550 r. p. m., with the help of pick off gears.

Each range comprises 4 automatic speeds, two backwards, two forwards.

The ratio of these 4 automatic speeds is : 1 (forward) : 2.35 (backward) : 3.5 (forward) : 8.25 (backward).